

# Work Order ID 67489

Wednesday, March 23, 2011 6:34:46 AM



Page 1

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/28/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-03-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

11-3-23

(9)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-3-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/6/23

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 2

[illegible]

**Abstract**

[illegible][illegible]

**Customer:**

\_\_\_\_\_

[illegible]

**Stop**

## Insp. Stamp

[illegible]

9

0.00

SB 11/03/08

[illegible]

0.00

0.00

8/103/28

40

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

0.00

0.00

START TIME:

10.00

□OVEN TEMPERATURE:

3:00 ☐ FINISH TIME:

1030

9 BL 11-3-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 67489**

Wednesday, March 23, 2011 6:34:46 AM



Page 3

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9 0 11/16/29

170

Identify as per dwg & Stock Location: *FP-21* 0.00

Packaging

Memo

0.00

Packaging

9 BR 11-3-29

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/3/30  
CMF  
11-03-29

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Wednesday, March 23, 2011 6:34:43 AM

Page 1

Work Order ID: 67489



Parent Item: D3508-3



Parent Item Name: Wearplate



Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	81.5938	0.734	6.181053	6.6		
											Bill-3-23		

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

81.5938

115953

21.6

116437

29.7538

116623

30.24

116 437

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

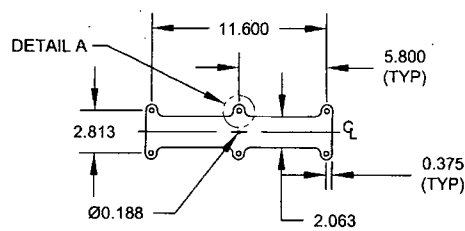
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

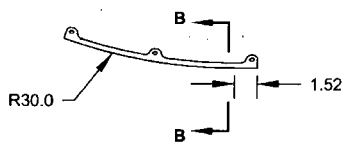
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NOTE: Date & initial all entries

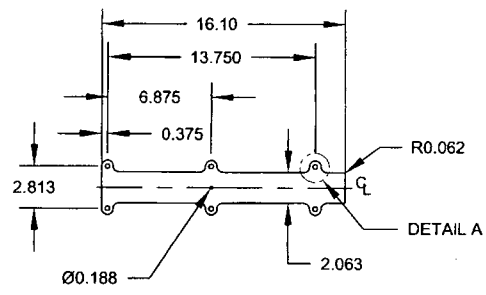




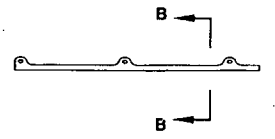
**D3508-1 FLAT PATTERN**



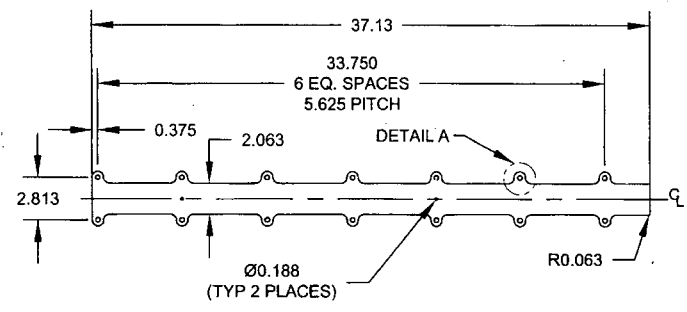
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



**D3508-7F FLAT PATTERN**



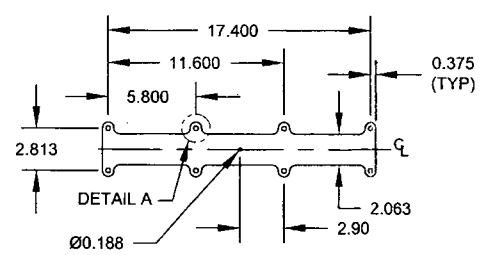
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



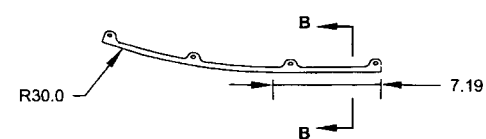
**D3508-3 FLAT PATTERN**



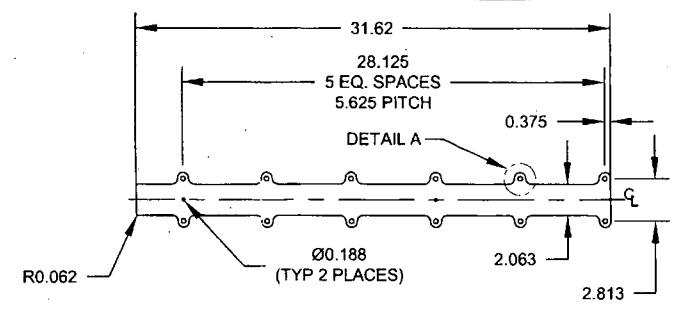
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



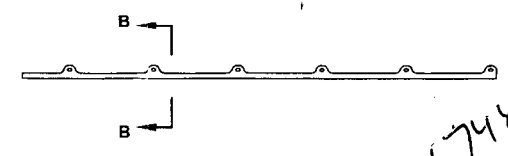
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.005 TO 0.015
  - 7) IDENTIFICATION: NONE
  - 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

**RELEASED**  
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

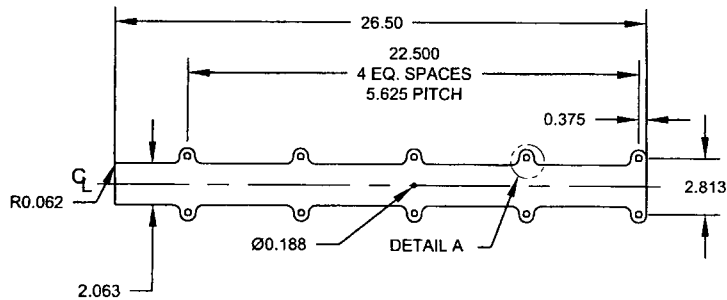
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

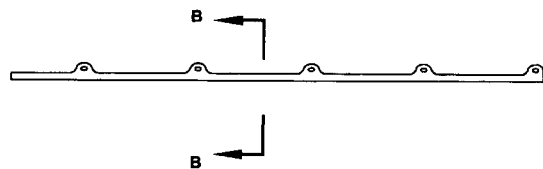
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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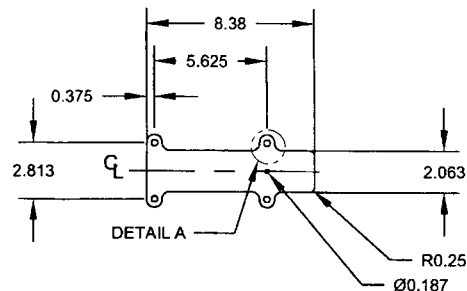
**NOTE:** Date & initial all entries



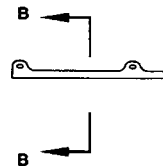
**D3508-11F FLAT PATTERN**



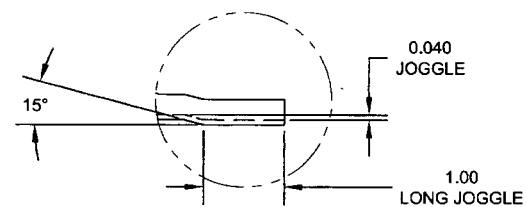
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



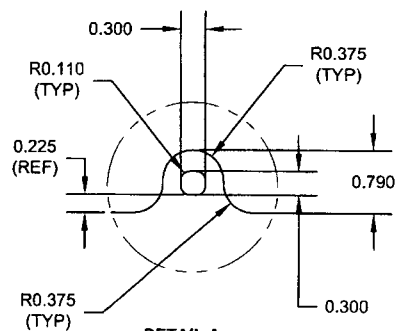
**D3508-13F FLAT PATTERN**



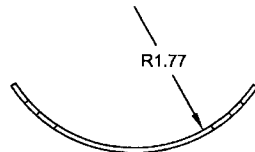
**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



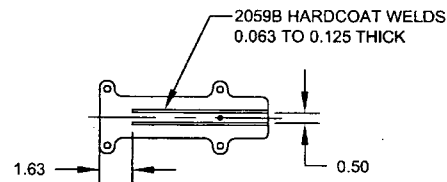
**DETAIL C**  
(SCALE 1:2)



**DETAIL A**  
(SCALE 2:3)







**SECTION B-B**  
(SCALE 2:3)



**D3508-13 WELDING DETAIL**

#67489

RELEASED  
07-11-16

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	67489
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3508-3
<b>Inspection Dwg:</b> D3508	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	X		V B02	
2.813	+/-0.010	2.812	V		V	
0.375	+/-0.010	.372	X		V	
5.625	+/-0.010	5.625	X		T B01	
33.750	+/-0.010	33.750	X		T	
37.13	+/-0.030	37.13	X		T	
Ø0.188	+0.005/-0.001	.191	X		V	
0.300	+/-0.010	.304	X		V	
0.300	+/-0.010	.303	X		V	
0.038	+/-0.010	.035	X		V	

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-3-23	<b>Date:</b> 11/03/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	JD

W/O:		WORK ORDER CHANGES					
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